

UTP A 673

Standards :

Material-No. : I.2606
 DIN 8555 : W/MSG 3-60-T
 EN 14700 : S Z Fe3

Wire for wear resistant surfacings on cold and hot working tools

Application field

UTP A 673 is used for the repair and production of hot working tools, such as die cast moulds, forging dies, hot cutting knives, hot-shear blades, axial rolls, roll mandrils, upset plates as well as for the production of working surfaces on non-alloy and low-alloy base materials.

Properties of the weld metal

Machining is possible with tungstene carbide tools.

Hardness of the pure weld deposit:

untreated 53 - 58 HRC
 soft annealed 820° C approx. 230 HB
 hardened 820° C / oil approx. 58 HRC
 tempered 600° C approx. 53 HRC
 1 layer on non-alloy steel approx. 45HRC

Weld metal analysis in %

C	Si	Mn	Cr	Mo	V	W	Fe
0,35	1,0	0,4	5,0	1,5	0,3	1,3	balance

Welding instruction

Clean welding area to metallic bright. Cracks in the base material have to be gouged out completely. Pre-heating temperature of 400° C on tools should be maintained. Stress relief, if necessary, at 550° C. Slow cooling.

Welding procedures and availability

Ø (mm)	Current type	Shielding gas EN ISO 14175					Availability	
		I I	M 12	M 13	M 21	C I	Spools	Rods
							EN ISO 544	EN ISO 544
1,2 *	DC (+)		x	x	x	x		
1,6 *	DC (+)		x	x	x	x		
1,6 *	DC (-)	x					x	
2,4 *	DC (-)	x					x	
3,2 *	DC (-)	x					x	

* available on request